

Date: Thursday, 10/25/2007 10:14:07 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 35375	
Estimate Number : 12494	
P.O. Number :	Part Number : D35147
This Issue : 10/25/2007 S.O. No. :	Drawing Number : D3514 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34822	Material :
Written By : <u>[Signature]</u>	Due Date : 11/15/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 07-09-24 JLM verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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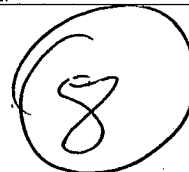


Comment: Qty.: 0.2518 sf(s)/Unit Total : 2.0143 sf(s)
6061-T6 .040 Sheet
(M6061T6S040)
Batch: 165842 HB 07-10-31

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3514
Dwg Rev: A HB 07-10-31
Prog Rev: A



Ensure Grain Direction is correct**

2-Deburr if necessary HB 07-10-31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-10-31

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6 7/10/31

counted
(x8)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Form Joggle as per Dwg D3514

HB 07/11/02

(7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 07/11/02
 QA: N/C Closed: _____ Date: _____

NCR: <u>35375</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/02	3	1 piece slide bender die bend out of Tolerance	<u>[Signature]</u>	Scrap & destroy	SP 07/11/02	<u>[Signature]</u> Muloz	<u>[Signature]</u>	<u>[Signature]</u> Muloz

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:14:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 35375

Part Number: D35147

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/06 (+F) counted

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 07-11-04 7

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 07/11/05 (+F) counted

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-106

AS 07/11/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



6 07-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

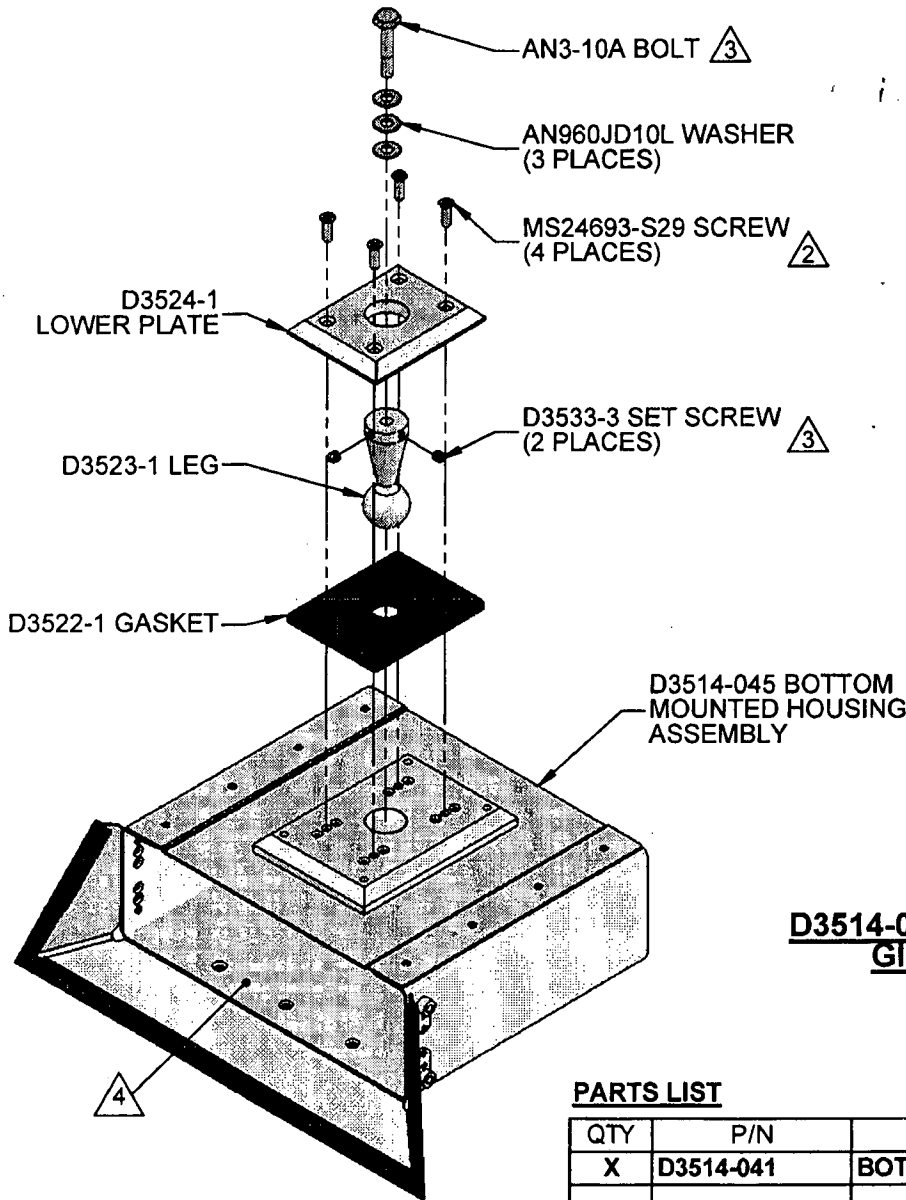
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	
REV A		DATE 07.06.18	SCALE 1:3
		DESCRIPTION NEW ISSUE	



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07.08.07

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

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WORK ORDER
NO. 35375

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

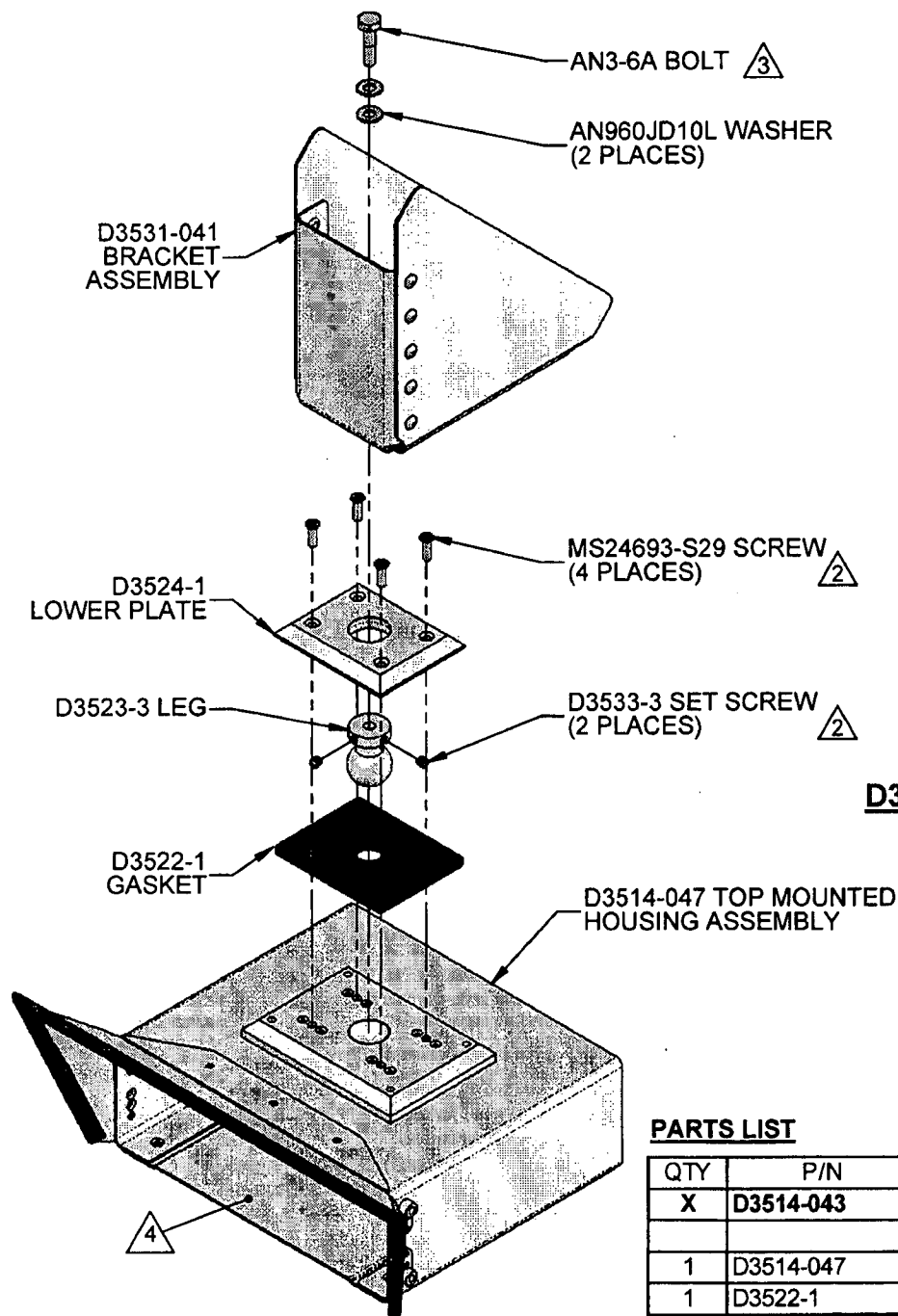
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 2 OF 9 SCALE 1:3

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D3514-043 TOP MOUNTED GIMBAL ASSEMBLY

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35315
WORK ORDER

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

PARTS LIST

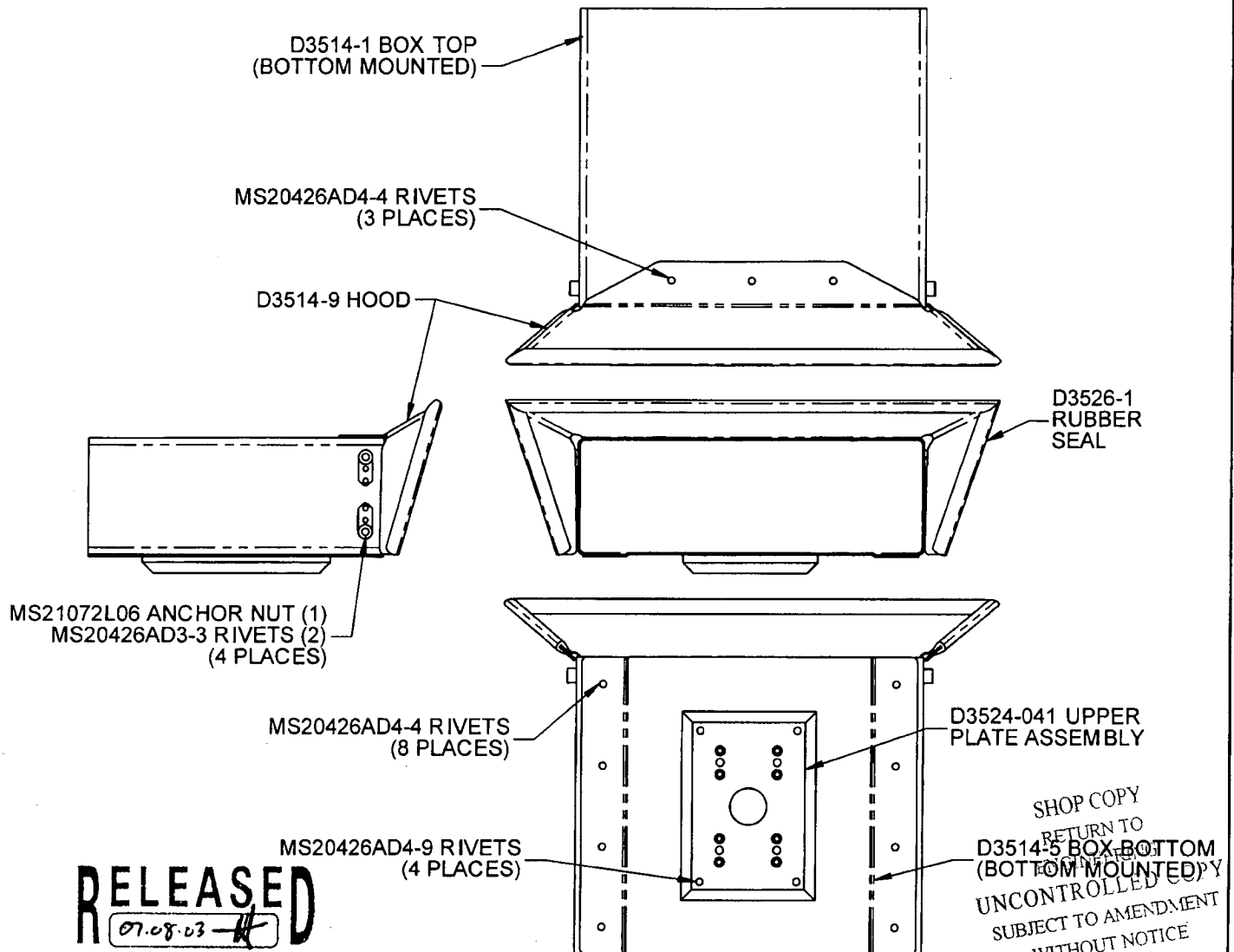
QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

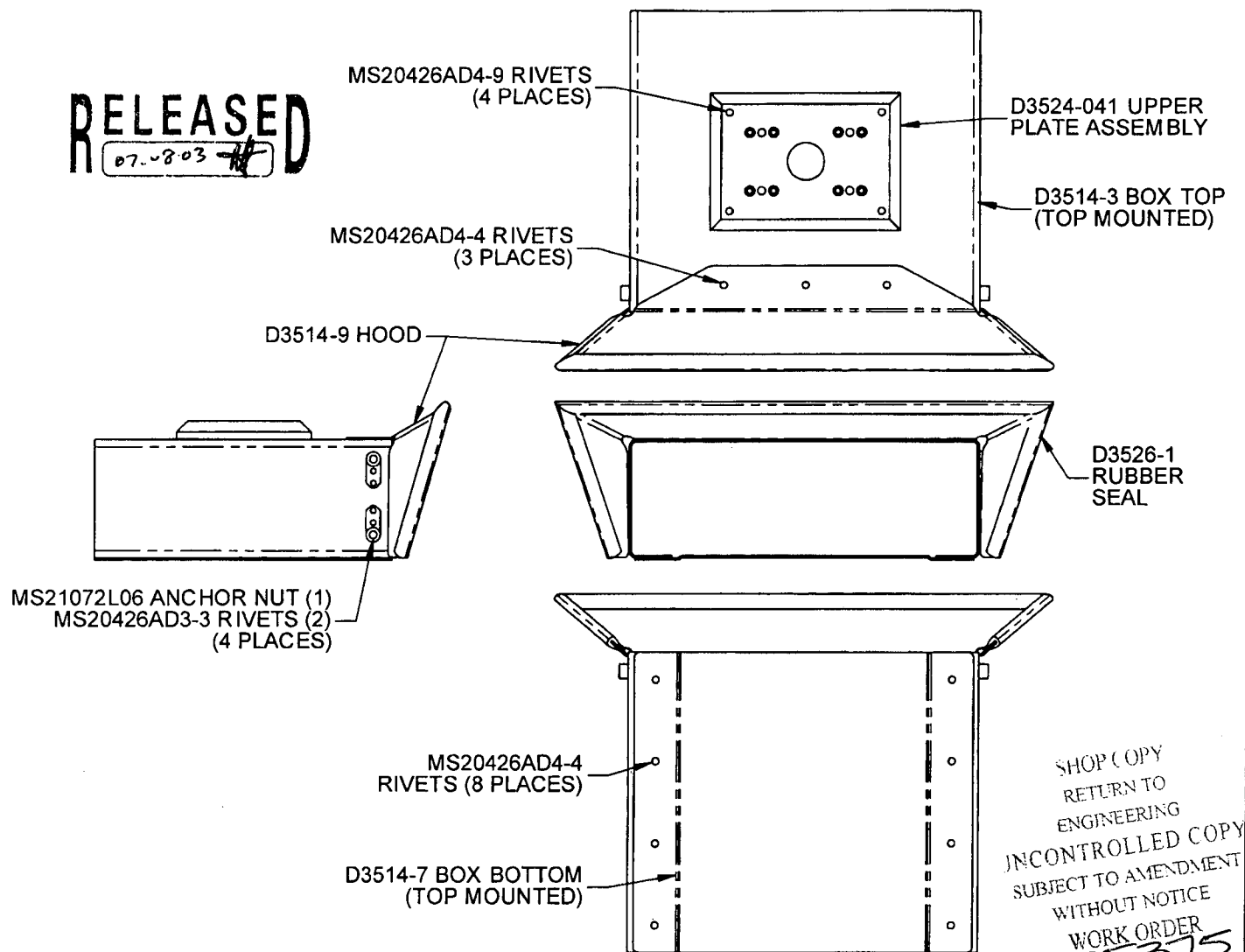
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**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

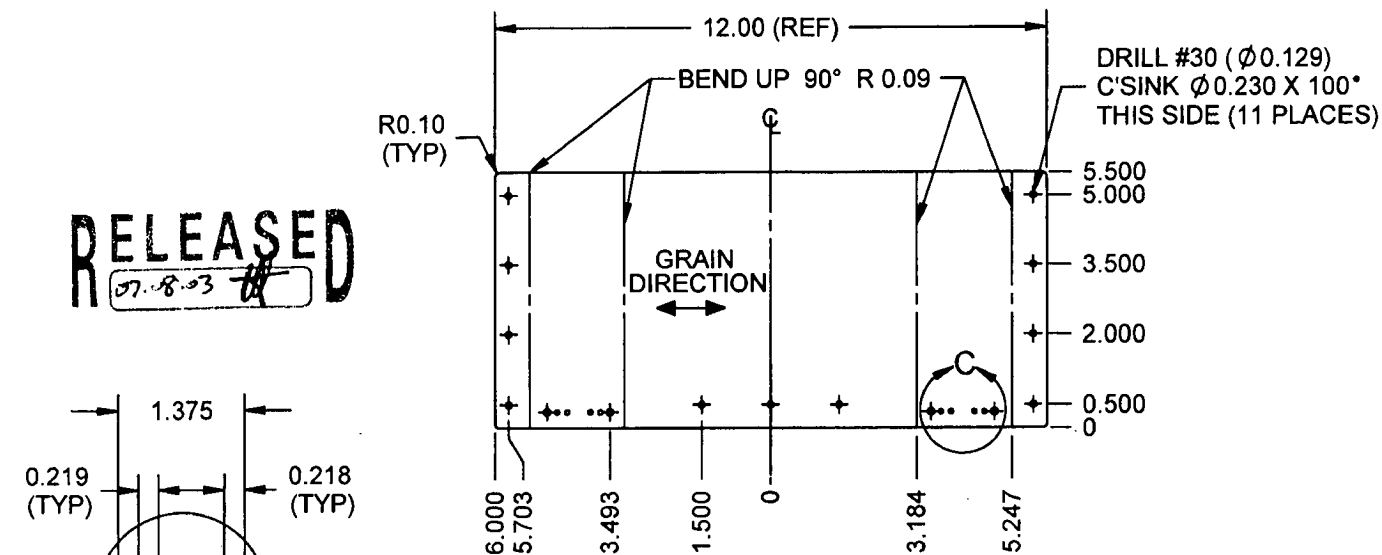
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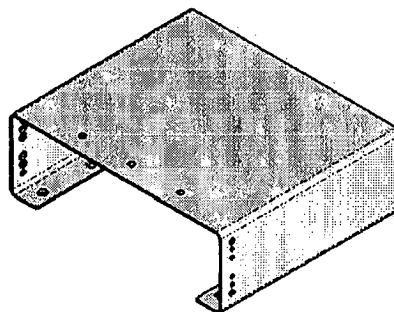


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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 5 OF 9 SCALE 1:4

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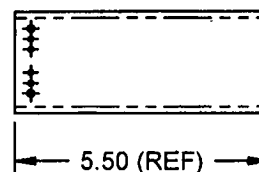
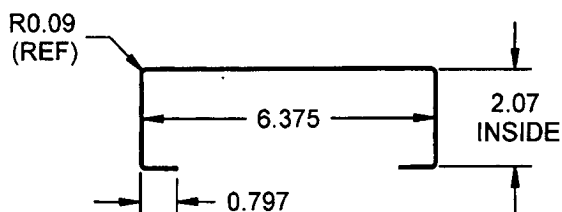
**D3514-1F
FLAT PATTERN**



**DETAIL C
SCALE 1:2**

DRILL #27 ($\phi 0.144$)
(4 PLACES)

DRILL #40 ($\phi 0.098$)
C'SINK $\phi 0.182 \times 100^\circ$ THIS SIDE
(8 PLACES) FOR RIVETS



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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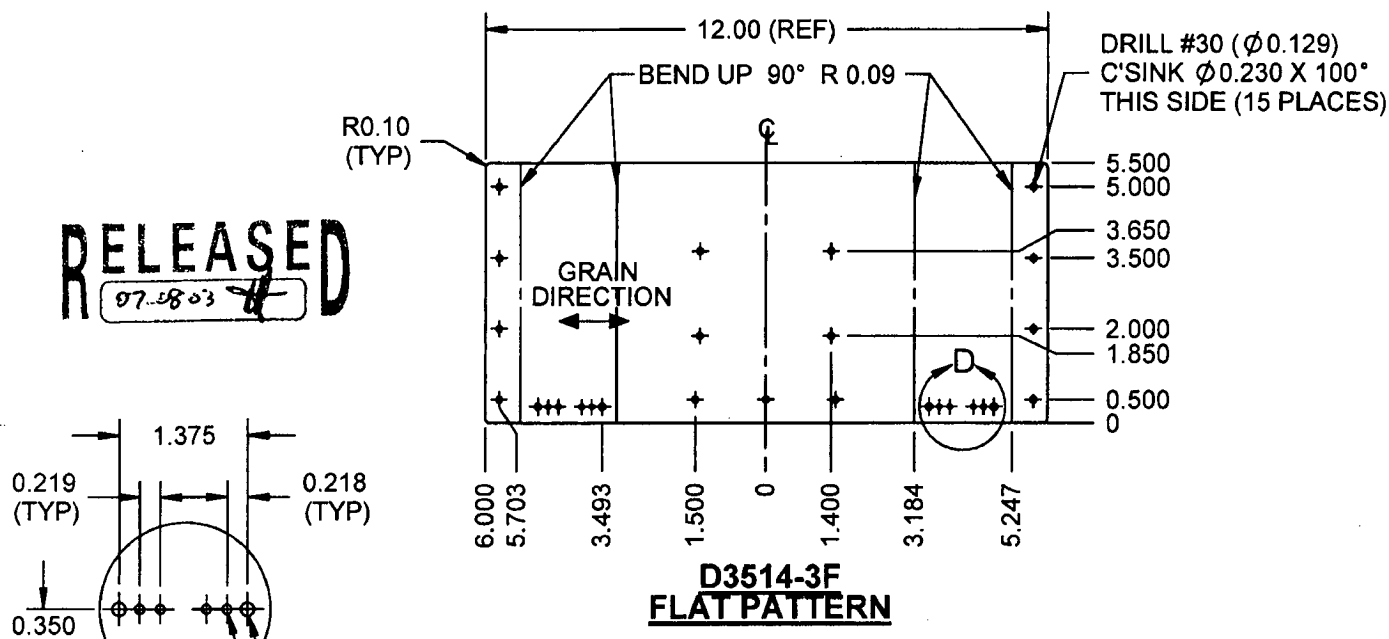
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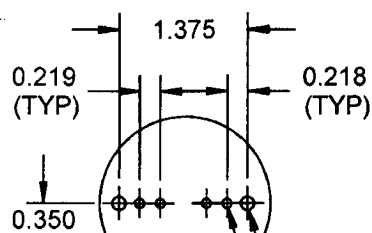


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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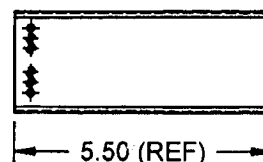
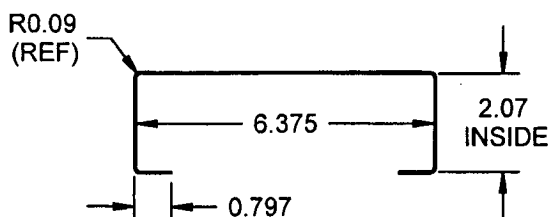
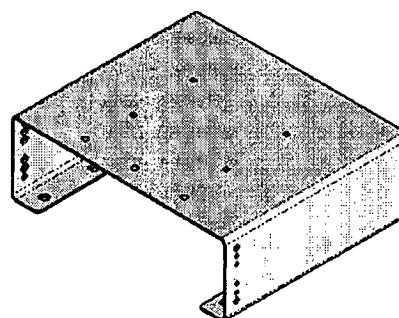
**D3514-3F
FLAT PATTERN**



**DETAIL D
SCALE 1:2**

DRILL #27 (Ø0.144)
(4 PLACES)

DRILL #40 (Ø0.098)
C'SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

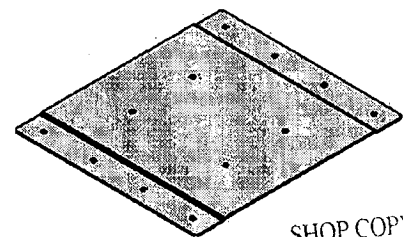
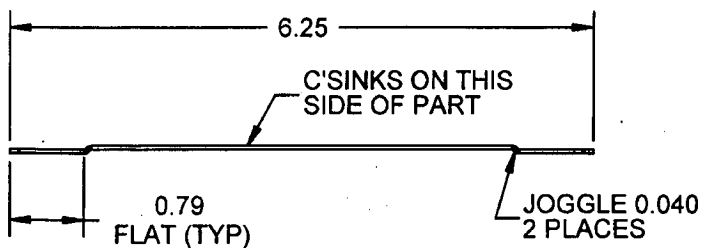
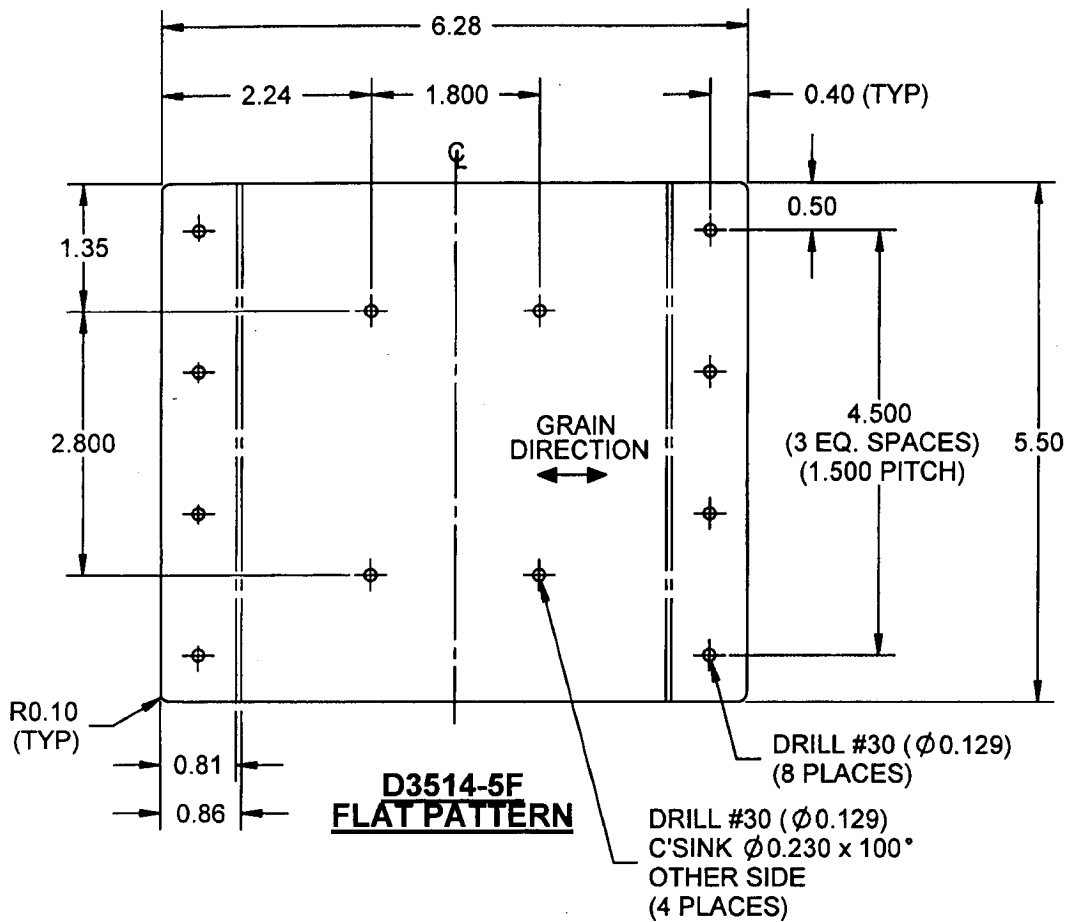
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 7 OF 9 SCALE 1:2



D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK ABOVE JOGGLE

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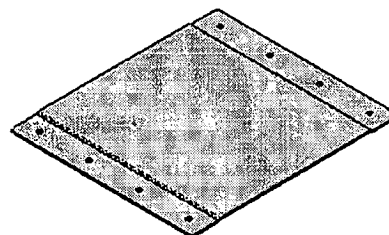
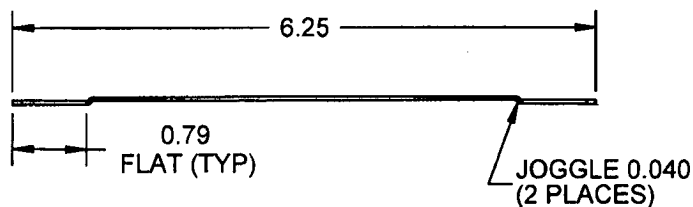
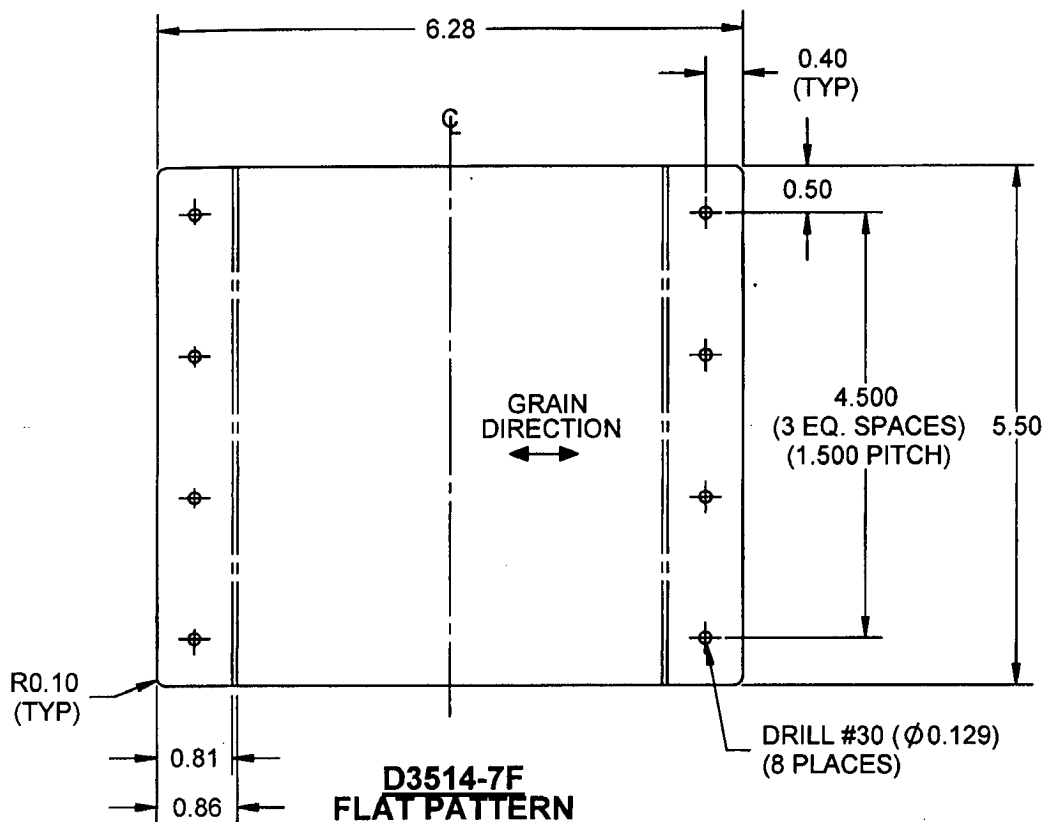
WORK ORDER
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 8 OF 9 SCALE 1:2



D3514-7 BOX BOTTOM (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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NO. 35375

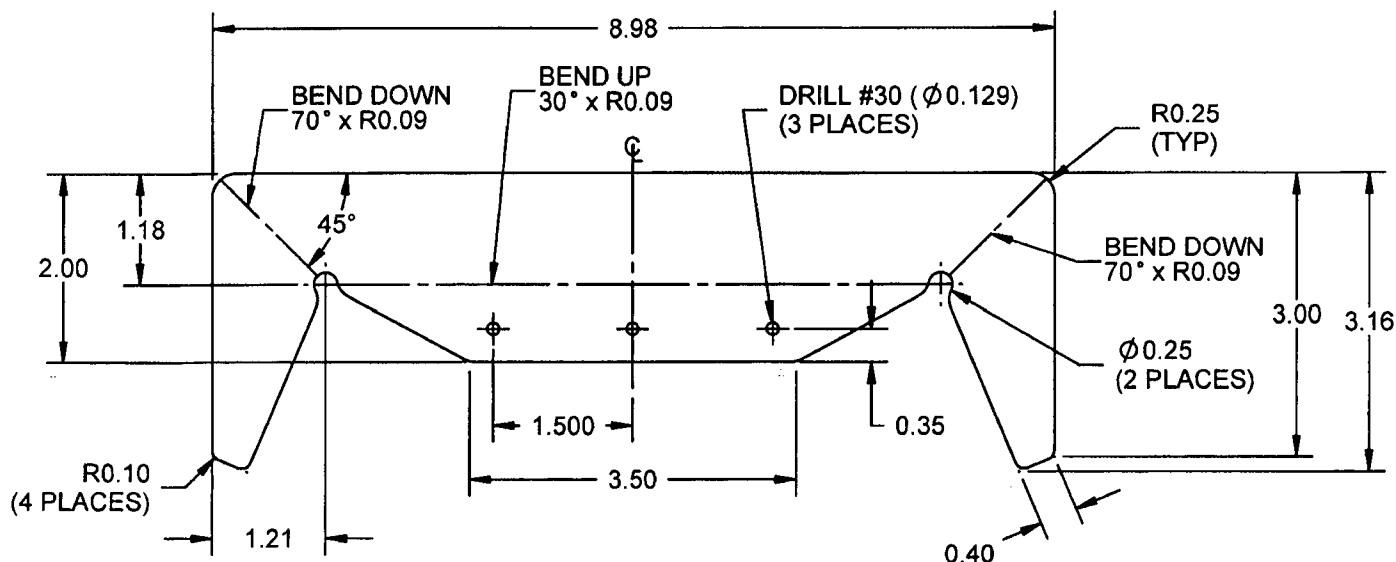
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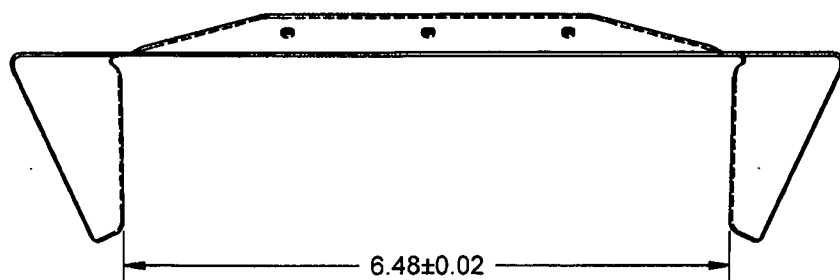
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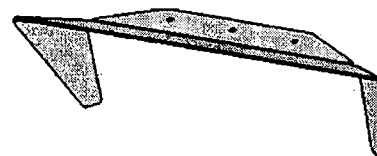
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 9 OF 9 SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW



D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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